
Page 1

Accept

[illegible]**Setup Start**[illegible]

Stop

Cust Item ID:

Start Date: 1/10/11 **Start Qty:** 10.00

[illegible]

Required Date: 1/18/11 **Req'd Qty:** 10.00

[illegible]

Customer:

Reference:

Run Start

Abstract

Approvals: **Process Plan:**

Date:**Tooling:**

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65252

January 10, 2011 10:33:58 AM



Page 2

Item ID: D3570-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 1/10/11 Start Qty: 10.00



Cust Item ID:

Required Date: 1/18/11 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(43)			
130 Small Fab Small Fab	Small Fab Memo 1-Form as per Dwg D3570 Using DT8945 2-Cut excess materials per Dwg D3570. 3-Drill as per Dwg D3570 Using Dt8946	0.00 0.00				(13x)			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(x13)			

⇒ m-k 11/01/12

8 11/01/12

-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65252

January 10, 2011 10:33:58 AM



Page 3

Item ID: D3570-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 1/10/11 Start Qty: 10.00



Cust Item ID:

Required Date: 1/18/11 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				13	Ø	11/01/13	
160 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 7:45 OVEN TEMPERATURE: 320° FINISH TIME: 8:15.	0.00 0.00				13	Ø	11-01-14	
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				13	Ø	11/01/14	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65252

January 10, 2011 10:33:59 AM



Page 4

Item ID: D3570-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 1/10/11 Start Qty: 10.00



Cust Item ID:

Required Date: 1/18/11 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location *Sylvie*

0.00



Packaging

Memo

0.00

Packaging

11/14 *SP* *130*

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/17 *[Signature]**MF*
11-01-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 10, 2011 10:33:57 AM

Page 1

Work Order ID: 65252



Parent Item: D3570-4



Parent Item Name: Bracket

Start Date: 1/10/11

Required Date: 1/18/11

Start Qty: 10.00

Required Qty: 10.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.125

Purchased

No

100

sf

67.6600

0.087

0.915789

1.1



1311-1-11

6061-T6 .125 Sheet

Location

Loc Qty

Loc Code

MAT21

67.66

113608

67.66

113608

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 65252
Description: Bracket		Part Number: D3570-4
Inspection Dwg: D3570	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.209	+0.005/-0.001	.212	x		V 180Z	
0.435	+/-0.010	.432	x		V	
0.658	+/-0.010	.654	x		V	
1.841	+/-0.010	1.841	+		V	
2.064	+/-0.010	2.066	+		V	
2.38	+/-0.030	2.376	x		V	
0.359	+/-0.010	.359	+		V	
0.557	+/-0.010	.558	+		V	
1.943	+/-0.010	1.941	+		V	
2.141	+/-0.010	2.140	x		V	
5.25	+/-0.030	5.249	+		V	
1.00	+/-0.030	1.006	+		V	
0.125	+/-0.010	.126	+		V	

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 11-1-11	Date: 11/01/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.11.09	New Issue	KJ	

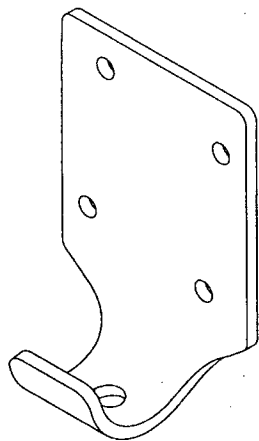
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

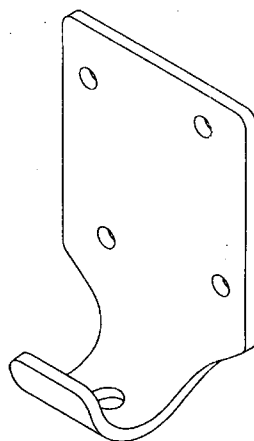
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

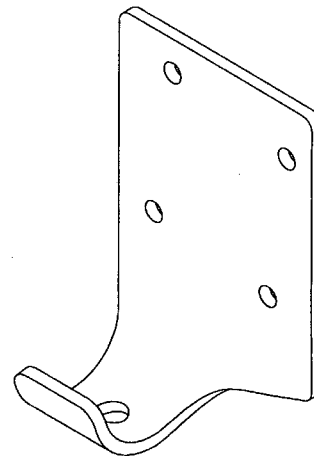
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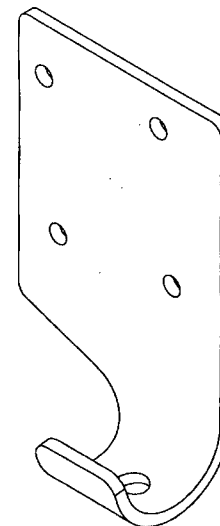
D3570-1 BRACKET



D3570-2 BRACKET



D3570-3 BRACKET



D3570-4 BRACKET

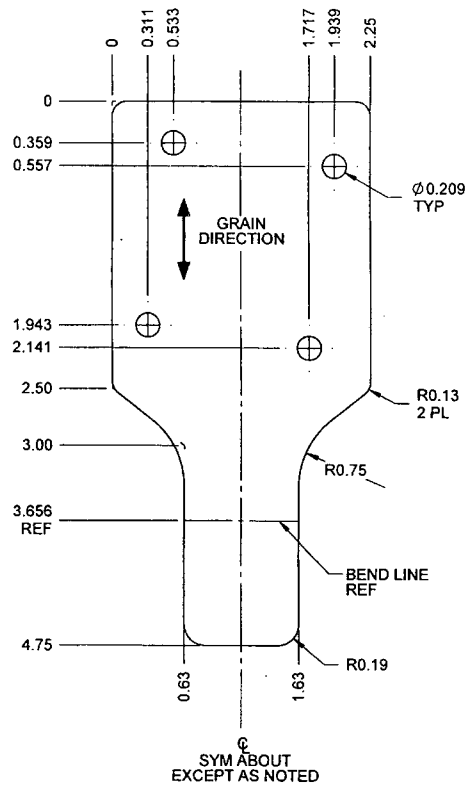
RELEASED
09/04/22

NOTES:

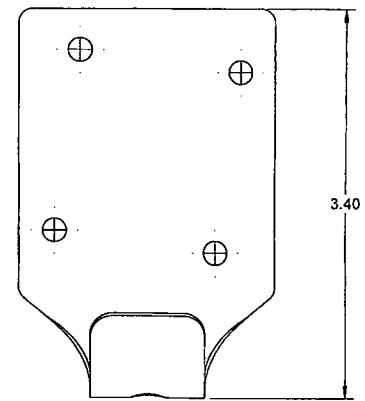
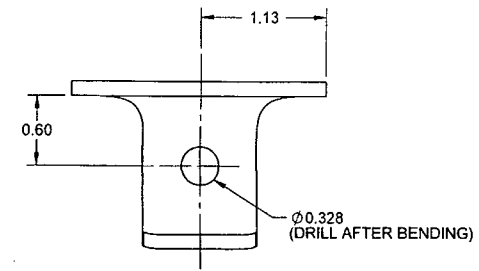
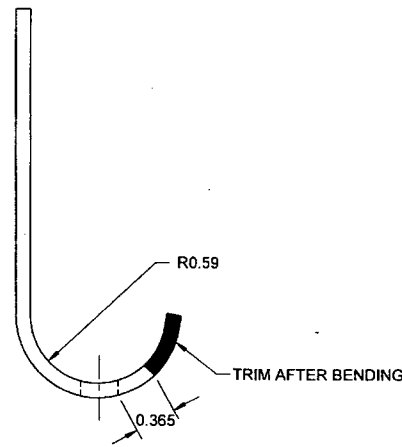
- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3570-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs EACH

u6065252

E	SHEET 3 UPDATED D3570-3F FLAT PATTERN, SEE REV D FOR DETAILS. SEE PAR 09-014.	AJS	09.04.22
D	ADDED -3 & -4 FOR USE ON 214B/B1. SEE PAR 09-014.	AJS	09.04.01
C	UPDATE DIMS FOR CLARITY	LE	07.06.01
B	CHANGE BEND RAD TO 0.60 FROM 0.50	LE	07.04.16
A	NEW ISSUE	LE	07.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO.	REV. E
CHECKED	<i>[Signature]</i>	D3570	SHEET 1 OF 5
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	BRACKET	NIS
DE APPR.	<i>[Signature]</i>	DATE 09.04.22	
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D3570-1F FLAT PATTERN

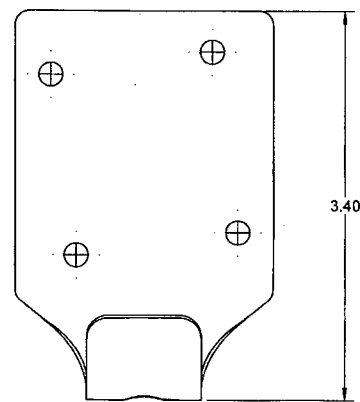
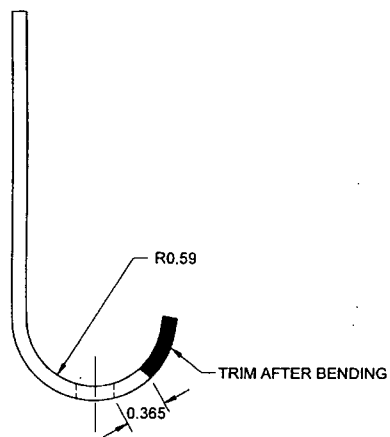
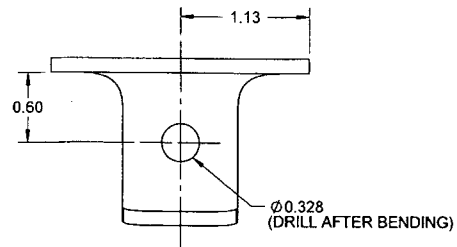


D3570-1 BRACKET
(MAKE FOM D3570-1F)

RELEASED
29/10/13 M3

65252

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3570	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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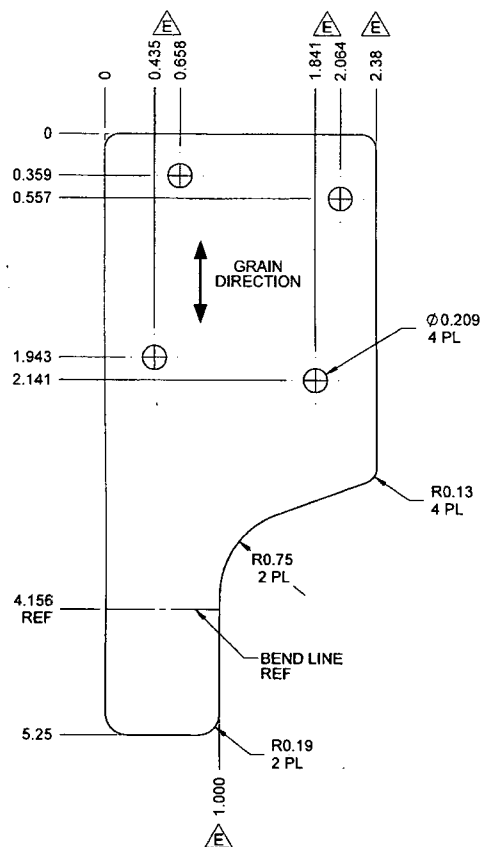


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(MAKE FROM D3570-1F)

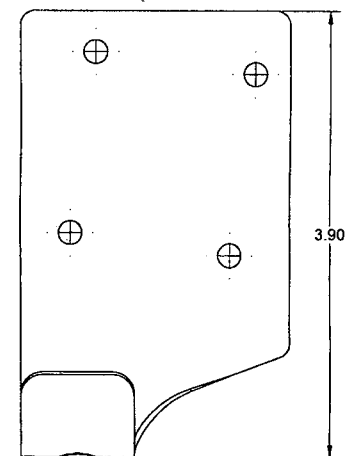
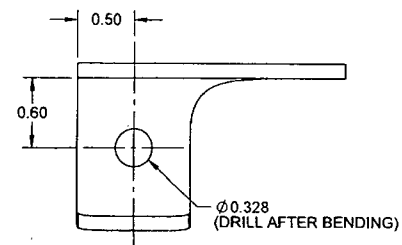
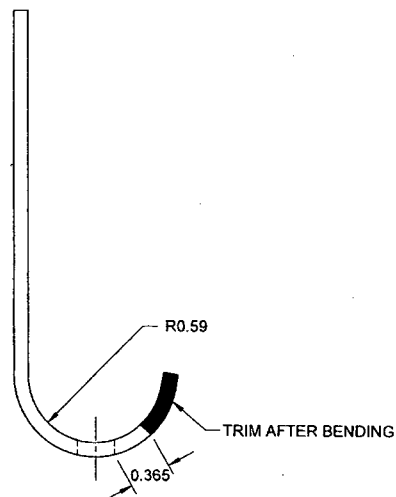
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DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	E	D3570	SHEET 3 OF 5
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D3570-3F FLAT PATTERN

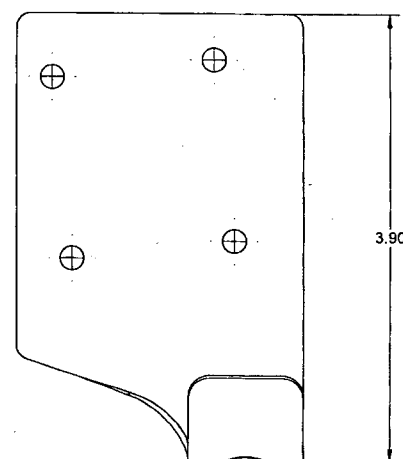
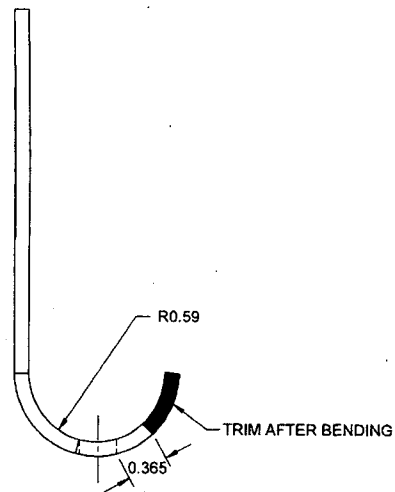
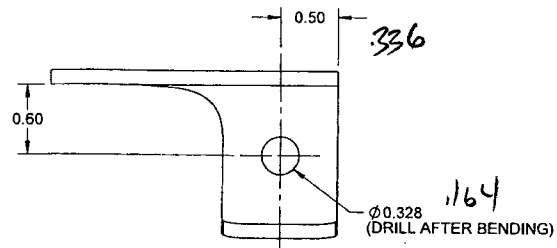


D3570-3 BRACKET
(MAKE FROM D3570-3F)

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09/04/22 MB

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DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AJS	DRAWING NO. D3570	REV. E
MFG. APPR.	AJS	SHEET 4 OF 5	
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D3570-4 BRACKET
(MAKE FROM D3570-3F)

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MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 5	
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